

5083738



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2500-3-100
Job Sheet 177952



Part No: D2500-3-100

Job Qty: 167 ea

Part Name: Ext'n -I' Beam Web 4"



JUN 25 2018

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/23/18

Job Tracking No:

Due Date: 6/25/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV H

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	167 pcs		6/25/18	0.00	0.00	Purchasing		18/06/25
110	Packaging	167 pcs		6/25/18	0.00	0.00	Packaging2		18/06/25
120	QC	167 pcs		6/25/18	0.00	0.00	QC6		18-06-27
130	Packaging	167 pcs		6/25/18	0.00	0.00	Packaging3		18-06-27
140	QC21-SA	167 Ea		6/25/18	0.00	0.00	QC21		21 JUN 27 2018

Part Op 100 - Issue P/O: 39972 a) Extrude as per Dwg D2500 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield
 Descriptions: tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 190" long
 g) Bon L Canada Inc. tool # 897105 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required j) Material
 certification is required
 110 - Ensure material certification is attached
 120 - Check Pull test per Dwg D2500 for compliance page attached. Check hardness with Webster tester
 130 - LOCATION : LG002

MAY 23 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-3-100P	Extrusion Round 3" 206	167 pcs (1 ea) 93	100-Purchasing	5083737

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2500-3-100P	167	0	0

Part Specifications

Specifications could not be found.

SPECIFICATION CONTROL DRAWING

D2500-1-XXX EXTRUSION & D2500-3-XXX EXTRUSION

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 36 KSI

MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI

MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: D2500-1 = 0.143 lb/in, D2500-3 = 0.086 lb/in

8) FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH (EX. D2500-1-190 IS 190" LONG). D2500-1 EXTRUSION MANUFACTURED FROM:

- A) BON L DIE # 807105 -> PREFERRED
- B) CARADON MIDEAST DIE # PAH-28030
- C) CARADON MTL DIE # MH-18868

9) FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG). D2500-3 EXTRUSION MANUFACTURED FROM:

- A) CARADON INDALEX DIE # MS-16867

RELEASED
2010-02-02
JMT

REV.	DESCRIPTION	BY	DATE
H	REDRAW & REFORMAT DWG; CORRECT BON L DIE # TYPO (2N B6-1); ADD AMS & ASTM MAT'L OPTION (2N D6-1); TOLERANCES NOW PER CARADON DWG (SHT 2)	CP	09.07.16
G	ADD DIE NUMBERS & DIMS IN INCHES NOTES	PH	07.04.17
F	CHANGE MAT. TO 6061-T6	DS	07.09.20
E	CHANGE MATERIAL TEMPER	DS	06.10.24
D	ADD MATERIAL PROPERTIES	DS	06.10.07
C	ADD D2500-3 WEB	BW	06.04.26
B	CHANGE INTERNAL WEB	DS	06.03.24
A	NEW ISSUE	DS	06.03.19
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. H

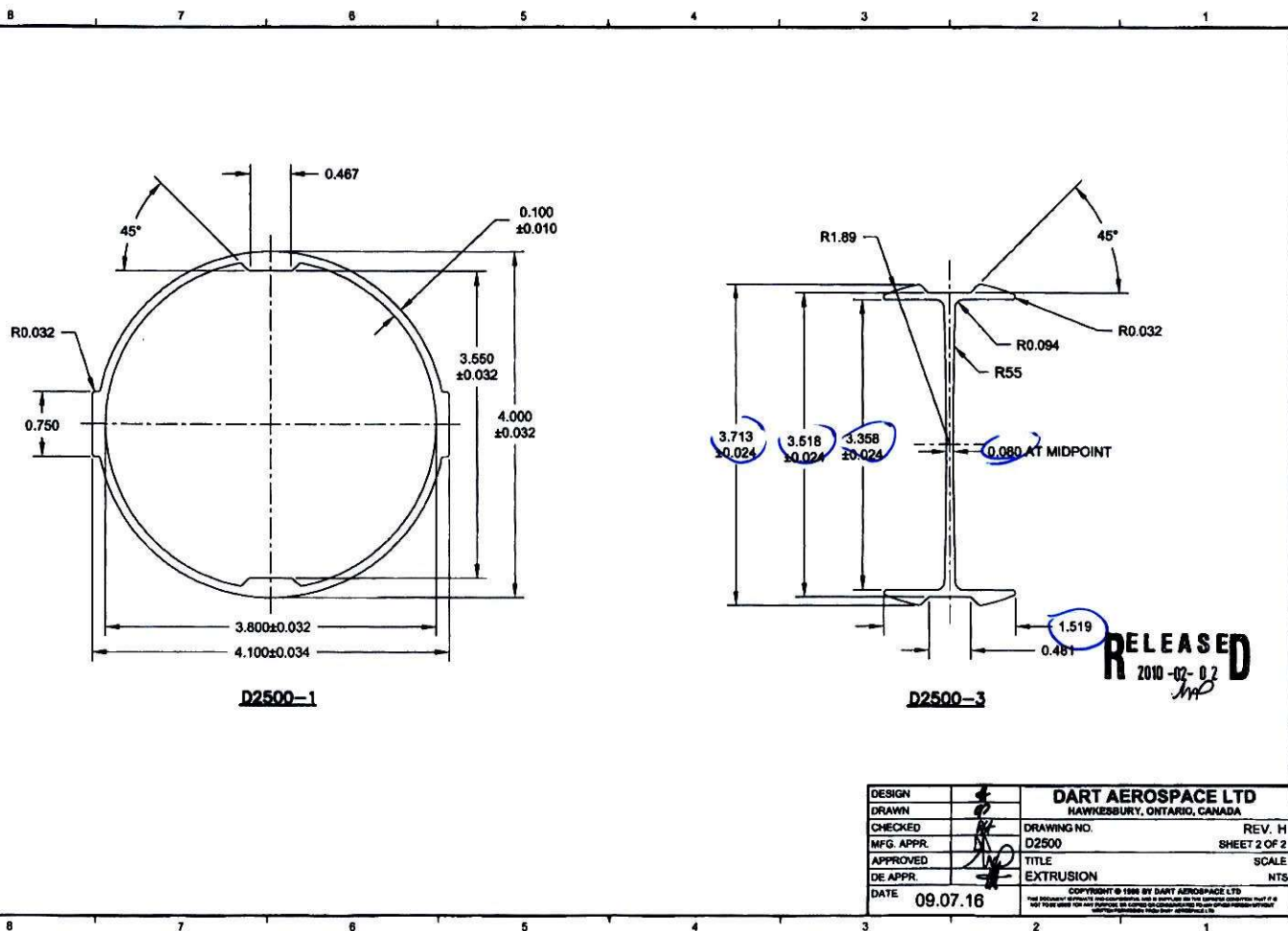
D2500 SHEET 1 OF 2

TITLE SCALE

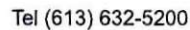
EXTRUSION NTS

COPYRIGHT © 1996 BY DART AEROSPACE LTD

THIS DOCUMENT IS UNCLASSIFIED AND UNRESTRICTED, AND IS AVAILABLE TO THE PUBLIC WITHOUT CHARGE. IT IS NOT TO BE USED FOR ANY PURPOSES THAT COULD BE DETRIMENTAL TO THE NATIONAL DEFENSE.



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2500	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		EXTRUSION	NTS
DATE	09.07.16	COPYRIGHT © 1986 BY DART AEROSPACE LTD	



PURCHASE ORDER
PO039972

Items

w/o 177952

MUST BE WELL PACKAGE. IF NOT IT WILL BE REFUSE

Grand Total: \$3,615.55

Order Notes

A049 SUPPLIER AWARENESS



HYDRO

Hydro Extrusion Canada, Inc

325, rue Avro

Pointe-Claire Québec H9R 5W3

Téléphone: (514) 697-5120

Télécopieur: (514) 694-8310

Packing Slip / Détail de Livraison

Packing Slip No /

Bon de Livraison

131377

Order no/

Commande

8051471 1

Ship to/Expédiée à DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONT K6A1K7				Sold to/Vendu à DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONT K6A1K7				Special Instr / Instr. Spéciales			
Cust No/No du Client 201355		Cust No/No PQ du Client 39972		PPD/PAYÉ X		Ord Dte/Dte Comm 18/05/23		Our Ord Dte/ Notre Dte la Comm 18/05/23		Hydro H.S.T #: R857314058	
PST/TPV * 6122-5207		Terms/Cond		Date Required/ Date Requite		Shipped/ Expedi 18/06/21		Shipped Via/ Expédiée Par OTTAWA 22 JUIN			
Item No	Ordered Weight Pcs/ Commande Poids Pcs	Hydro Die no/ Matrice d'Sapa	Customer Description/ Description de Client	Alloy & Temper/ Alliage et Trempage	Length Longueur	Backorder Wgt Pcs Arrière Poids Pcs	This Shipment Bdls Pcs Wght Com Expédiée Ballots Pcs Poids				
1	499 167		DUE = 2018/06/22 JN25 D2500-3 MS 18867 D2500-3-100 6061 T6 2540MM BUNDLE = 1359229 We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures				1	93	262	KGS	

Aluminum Extrusions - Anodizing - Fabrication - Painting
Profils D'Aluminum - Anodisation - Fabrication - Peinture

The above items were received in good order.
Les articles ci-dessus ont été reçus en bon ordre.

By/Par.....

325 rue Avro
Pointe-Claire, QC, Canada H9R 5W3
Téléphone (514) 697-5120
Fac-simile (514) 694-8310



Rapport des propriétés mécaniques Certified Test Report

Client / Customer: **DART AEROSPACE LTD**
Adresse / Address: **270 ABERDEEN STREET
HAWKESBURY ONT,
K6A 1K7**

commande Hydro / Hydro order #: **8051471**

bon de commande / Purchase order #: **39972**

de matrice / Die #: **MS 18867**

Alliage & trempage / Alloy & temper: **6061 T6**

Contrôle / Control #: **14241-1**

Coulée / Cast #: **72376**

Description: **D2500-3**

Customer Part #: **D2500-3-100**

Conductivité / Conductivity: **N / A**

ASTM B221-14

Propriétés mécaniques Mechanical Properties	Min.requis Min.required	Résultat actuel Actual results
Tension ultime Ultimate stress(ksi)	38 0 ✓	45.4
Contrainte élastique Yield stress (ksi)	35.0 ✓	41.3
% élongation dans 2" % elongation in 2"	8 ✓	10.0
Dureté Rockwell E (hre) Rockwell E Hardness (hre)	88 @ 100 ✓	93 ✓

Composition chimique Réelle / Real chemical composition :

Alliage	Cast no	Cu	Mg	Si	Fe	Mn	Ti	Zn	Cr
N / A									

Certificat

Hydro Extrusion Canada, Inc. certifie par la présente que le métal expédié sous ce rapport a été testé conformément à la norme ASTM identifié et / ou spécifications ASME et les résultats de l'analyse chimique et les propriétés mécaniques des tests sont dans les plages d'acceptabilité des spécifications. La garantie du produit est régie par Extrusion Amérique du Nord. Les conditions standard des ventes sont affichées sur la page web : www.hydroextrusions.com/termsconditions.

Certification

Hydro Extrusion Canada, Inc. hereby certifies that the metal shipped under this report has been tested in accordance with the identified ASTM and/or ASME specifications and the results of the chemical analysis and mechanical properties tests are within the acceptable ranges of these specifications. Any product warranty is governed by the Extrusion North America Standard Terms and Conditions of Sale posted at www.hydroextrusions.com/termsconditions.

Sincèrement vôtre,
Yours truly,

Date : **2018-06-18**

Daniel Alfredo Pelletier
Directeur Qualité
Quality Manager

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2500-3-100
 DATE: 18.06.27

PO / BATCH NO.: P03972/S083738

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 93
 QUANTITY INSPECTED: 93
 QUANTITY REJECTED: 0

THICKNESS ORDERED: N/A
 THICKNESS RECEIVED: N/A
 SHEET SIZE ORDERED: N/A
 SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL PER M-DRAWING	(Y) N	ASTM B221
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	(Y) N	P03972
CORRECT MATERIAL IDENTIFICATION	(Y) N	
CORRECT M# ON THE MATERIAL	(Y) N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DD</u>	SIGNED OFF BY: _____
DATE: _____	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in